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RBE703A94-1130-01

Job Sheet 183076



Part No: RBE703A94-1130-01

Job Qty: ~~4~~ 5

Part Name: Main Rotor Blade Trim Tab Tools Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/17/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev A 17.10.27 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		9/17/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	4 pcs		9/17/18	0.00	4.00	Small Fab-3		MLC
120	QC	4 pcs		9/17/18	0.00	0.00	QC5		SD 18/12/18
130	Packaging	4 pcs		9/17/18	0.00	0.00	Packaging3-1		DPMLC
140	QC21-FG	4 Ea		9/17/18	0.00	0.00	QC21		21 DEC 06 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	16 Ea (4 ea)	90-Start up Operation	
APP-1450-E	Case	4 Ea (1 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	90-Start up Operation	
RBE703A94-1130-01-01	Immobilizing Clip Assembly	4 Ea (1 ea)	90-Start up Operation	5135032
RBE703A94-1130-01-23	Deflection Clip Assembly	4 Ea (1 ea)	90-Start up Operation	5135258
RBE703A94-1130-01-47	Bottom Foam use in case APP-1450-E	4 pcs (1 ea)	90-Start up Operation	
RBE703A94-1130-01-49	Top Foam use in case APP-1450-E	4 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	16	539	0
	APP-1450-E	4	17	0
	RB41011	4	791	0
	RBE703A94-1130-01-01	4	1	0
	RBE703A94-1130-01-23	4	5	0
	RBE703A94-1130-01-47	4	17	0
	RBE703A94-1130-01-49	4	17	0

Part Specifications

Specifications could not be found.



Container No: S135290



Part: RBE703A94-1130-01

Job No: 183076

Serial No/Batch: S135290

Revision: K

Inspector:

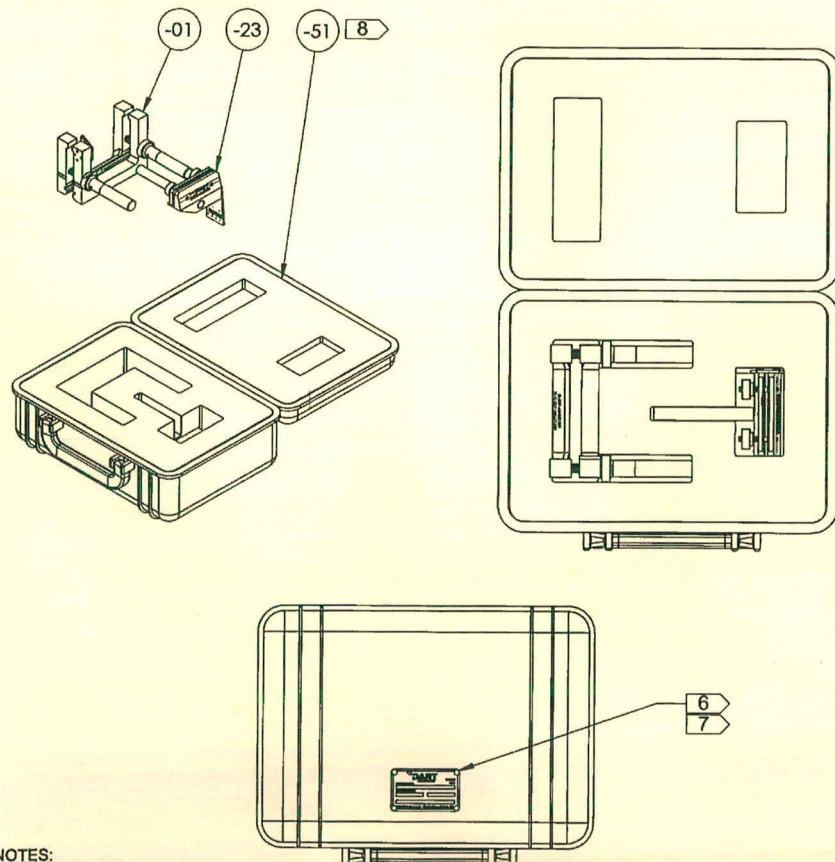
Exp Date:

Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/06/18

ITEM #	QTY	PART #	TITLE	PG
-01	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSY	2
-23	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSY	9
-51	1	RBE703A94-1130-01-51	PACKAGING ASSY	15
52	1	RB41011	DART PLACARD	-
53	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

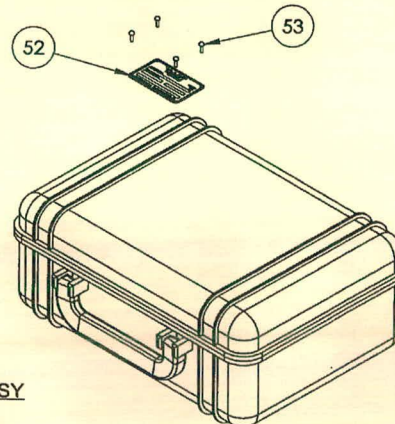


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N WHERE INDICATED ON DART PLACARD (ITEM 52) BEFORE INSTALLATION ON THE PELICAN CASE (ITEM 45)
- 7) CENTER DART PLACARD (ITEM 52) IN AVAILABLE AREA OF THE PELICAN CASE'S LID (ITEM 45)
- 8) HOT GLUE TOP AND BOTTOM FOAM (ITEM -47 & -49) INTO THE PELICAN CASE (ITEM 45) AFTER DART PLACARD'S (ITEM 52) INSTALLATION
- 9) OEM P/N: E-703494-1130-01

RBE703A94-1130-01 MAIN ROTOR BLADE TRIM TAB TOOLS ASSY

REV.	DESCRIPTION	DATE	BY	APPROVED
1	MOVED PINS -27, -28 FROM PAGE 3 TO 4. CHD ENGRAVE NOTE PIN -03. CHD HOLE DIA. PIN -25 & ADDED P.F. CHD DOWEL DIM TO METRIC ONLY. CHD PIN -27 ROLL PIN HOLE DIA TO 4mm ONLY ADDED P.F., CHD RADIUS DIM PIN -27. CHD DOWEL DIM TO 4mm ONLY ADDED DEPTH 354. CHD RADIUS DIM -29.	5/1/2009	RJC	RW
1A	-49 ADDED LID FOAM.	4/13/2011	RJC	RW
2	CHD -03 & -09 NOTE 1 PER R.W. CHD -05 DOWEL PIN HOLE FROM 0.118in. [3mm] PER G.E. -09 CHD C-DRILL FROM 0.04mm TO 0.170 PER G.E. CHD -11 0.118 HOLE FROM P.F. TO 3.5 PER G.E. CHD -21 FROM 0.03mm X 20mm PER R.W. ADDED -29 DIMENSION 1.250in. [32mm] TO ENSURE -25 WILL S.F. INTO -27 PER G.E. CORRECTED -27 & -29 CHAMFER DIMENSION FROM 1.97in. TO .197 PER G.E. ADDED -51 TO BOM. CHD -41 FROM DOWEL PIN.	9/16/2011	RJC	-
2A	ADDED -09 MISSING 0.03mm HOLE P.F. -19 DIMENSION. ADDED -27 MISSING R.042 DIMENSION PER G.E.	5/21/2012	RJC	GE
2B	CHD -03 & -09 FINISH FROM CLEAR ANODIZE TO RED ANODIZE. REMOVED POWDER COATING NOTES. CHD -07 WAS #91310A558 STEEL TO #91287A165 S.S. CHD -47 WAS ROLL PIN TO DOWEL PIN.	4/17/2013	CFS	RW
3	-03, -08, -27 CHD ENGRAVE NOTE WAS RBEA4-1130-01 IS RBE703A94-1130-01. -08 CORRECTED VIEWS. CHD DIM WAS 0.315 1.25 IS 0.315 1.25 S.F. CHD DIM WAS 0.128 THRU IS 0.129 1.25. 07 ADDED DIM S.F. -35. CHD DIM WAS 0.125 FOR -21 IS 0.129 1.25 THRU. -09 CHD DIM WAS 0.118 P.F. -19 IS 0.118 0.076 (X). -11 CHD DIM WAS 0.118 S.F. -19 (X2) IS 0.1208 1.197 (X2). -25 CHD DIM WAS 0.04mm P.F. -41 IS 0.1575 1.572. CHD DIM WAS 0.625 S.F. -27 IS (0.625) S.F. -27. -27 CHD DIM WAS 0.04mm THRU S.F. -41 IS 0.1607 1.592 S.F. -41. CHD DIM WAS 0.04mm 354 (X2) IS 0.1575 1.572 354 (X2). ADDED MISSING DIM 236. -31 CHD DIM WAS 0.157 S.F. -41 (X2) IS 0.1607 1.592. ADDED MISSING DIM (394). -47 ADDED DIM (4X) R.37.	6/24/2013	BIM	RW
4	-25 CHD DIM WAS LIMITS 0.1572 TO .1575 IS LIMITS 0.1564 TO .1570. -27 CHD DIMS WAS 0.1592 TO .1607 IS 0.1575 1.580. WAS 0.1572 TO .1575 IS 0.1567 1.571. -31 CHD DIM WAS LIMITS 0.1592 TO .1607 IS 0.1578 TO .1655.	4/10/2014	DPD	GE
5	SEE ECR 16-0272	12/30/2016	RJC	SM
6	SEE ECR 17-0164	6/26/2017	RJC	JAG
K	SEE ECN 17 623 : TEMPLATE UPDATE AS PER HAWKESBURY STANDARDS. -07 MATERIAL CHANGE FROM M8 SCREW TO M304R AND TOLERANCE .315/ .306 CHANGE TO .307 +/- .003 AND THREAD CLASS ADDED. -05 TOLERANCE .315/ .316 CHANGE TO .309 +/- .003/-0. ASSY -51 ADDED. RIVETS AND EMPLACEMENT OF THE PLACARD ON THE PELICAN CASE ADDED	11/20/2017	VM	WM



DART AEROSPACE Hawkesbury, Ontario, Canada		TITLE	
		MAIN ROTOR BLADE TRIM TAB TOOLS ASSY	
DWO NO.		REV	
RBE703A94-1130-01		K	
DESIGN BY:	VM 9/11/2017	XXX ± .005 FRACTIONS ± 1/8"	✓
DRAWN BY:	VM 11/24/2017	XX ± .01 ANGLES ± 2°	
CHECKED BY:	WM 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	✓
MFG. APPR:	DP 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED BY:	WM 11/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	✓
DATE:	11/24/2017		
SCALE:	NTS	WEIGHT:	N/A
		SHEET 1 OF 17	
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